

REMARKS/ARGUMENTS

This application is a divisional application of U.S. application serial no. 09/887,433, filed June 25, 2001, allowed.

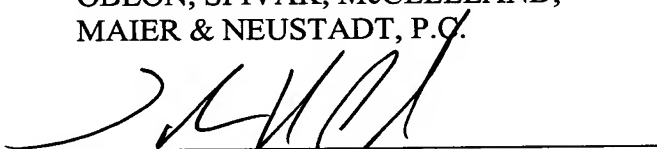
Claims 1-4 and 16-17 are presented for examination, the non-elected claims having been cancelled. New Claims 16-17 find support at Claims 3-4 as originally filed. The multiple dependencies of Claims 3 and 4 have been removed.

The substitute specification is submitted, consistent with the parent case.

No new matter is believed to be added. This case is now ready for examination on the merits.

Respectfully submitted,

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- 1 -

# CROSSLINKED FINE PARTICLES AND CURABLE RESIN COMPOSITION

## BACKGROUND OF THE INVENTION

### (1) Field of the Invention

The present invention relates to a resin composition useful as ~~an~~ a radiation curable resin composition, a thermosetting resin ~~compositions or the~~ like composition, and it relates to, in particular, a resin composition that ~~can have all of~~ has a low viscosity, a low shrink ~~properties~~ property and a rapid-curability, unlike a conventional curable resin ~~compositions~~ composition.

### (2) Description of the Related Art

Radical-polymerization type radiation curable resin compositions are utilized in the field of ~~various~~ surface fabrication ~~fields~~ because they are rapidly curable at low temperatures, and ~~give a~~ the cured coating ~~film~~ films have excellent ~~in~~ scuff and chemical resistance, ~~chemical resistance~~. ~~And the like~~ However, ~~The~~ the radiation curable resin compositions ~~however,~~ usually tend to have a high ~~viscosity~~ viscosities at room temperatures. ~~It is, therefore~~ Therefore, it is necessary to reduce the ~~viscosity~~ viscosities in order to facilitate ~~their~~ application.

~~The use of organic~~ Organic solvents or diluent monomers having low viscosities are necessary

for viscosity reduction of the curable resin compositions. AS a result, environmental concerns such as increased volatile organic compound (VOC) contents, skin irritation caused by the diluent monomers, along  
5 with the decreased curing rates of said resin compositions are observed.

In general, radiation curable resin compositions shrink remarkably in volume upon curing, and therefore, a method comprising the addition of a  
10 high-molecular weight oligomer or polymer is adopted to reduce the percentage of shrinkage. However, when this method is adopted, the viscosity of the resin is increased and the coating properties are deteriorated; further the coating curability deteriorates by the  
15 decrease in the resin concentration at the reaction site.

~~Also in the field of, for example,~~ film coating materials, for example, radiation curable resin compositions draw attention. For instance, JP-A-3-  
20 252460 discloses a composition for coating material which comprises an ethylenic unsaturated compound having a molecular weight of 500 or less, a styrene-based polymer having a softening point of 70°C or higher, and a photopolymerization initiator ~~and is~~  
25 which has excellent ~~in~~ adhesive properties to various substrates, high gloss, blocking resistance, scratch resistance, water resistance, etc.

However, since the aforesaid composition

contains ~~the~~ a styrene-based polymer having no photo-reactivity, its viscosity ~~tends to~~ becomes so high that the coatability ~~should be~~ is poor depending on the amount of the styrene-based polymer added. Moreover, since a large amount of the photopolymerization initiator ~~has to~~ must be incorporated into the composition in order to attain a high productivity, a large amount of the photopolymerization initiator remains in a the cured coating film, resulting in a film product having the unpleasant odor of the photopolymerization initiator. Thus, ~~no~~ a product having satisfactory overall performance characteristics could not be obtained.

~~Also in~~ In the field of coating materials for wood coatings, rapid-curing radiation curable compositions ~~of rapid-curing type~~ have come to be extensively used which entail a low energy cost and are good in productivity. Of these radiation curable compositions ~~utilized in the said field, compositions,~~ those that contain containing an unsaturated polyester resin, inter alia, have been extensively used because they give a cured coating film that is excellent in finished appearance involving gloss, and feeling of fleshiness, and they are inexpensive.

However, in the case of a coating film having ~~of~~ such a composition, the surface curing speed is lower than ~~it~~ the in-depth curing speed, resulting in an insufficient productivity of ~~an~~ the applied and

cured product. Moreover, since the internal strain of the cured coating film is increased by the cure shrinkage of one or more monomers and oligomers contained in the composition, the composition has the  
5 disadvantage~~is disadvantageous~~ in that the cured coating film tends to be cracked by ~~the repetition of~~  
repeated heating and cooling.

To overcome these problems~~For removing these defects, for example,~~ JP-A-4-202213 discloses a  
10 composition using a maleic acid-based unsaturated polyester containing a specific glycol component, and JP-A-5-202163 discloses a composition using an epoxy acrylate, a specific acryl polyol component and an isocyanate compound.  
15 The composition disclosed in JP-A-4-202213, ~~however,~~ requires the use of styrene monomer as a diluent ~~for improving~~ to improve the coating efficiency. The use of styrene monomer deteriorates the surface curability, however, and ~~moreover,~~ the work  
20 environment is harmed by odor ~~diffused by~~ from the volatilization ~~or~~ f the styrene monomer. The composition disclosed in JP-A-5-202163 also faileds to improve the work environment because it has a high  
- viscosity and hence requires the use of a diluent, such  
25 as an organic solvent, ~~for improving~~ to improve the coating work efficiency required for ~~to put the composition to~~ practical use.

In recent years, printing inks ~~curable~~ that

can be cured by active energy rays such as electron rays, ultraviolet rays, visible rays, etc. have been increasingly substituted for common oil inks ~~in an~~ ~~increasing fields and used increasingly~~, because of their many advantages, such as ~~speeding up~~ faster printing, ~~speedy~~ and delivery, hygienic properties, etc. These printing inks comprise a composition containing a radical-polymerizable monomer, an oligomer and a coloring agent such as a pigment. As specific

10 examples of the printing inks, the composition systems which also ~~use~~ use in combination a diallyl phthalate-based polymer disclosed in, for example, JP-B-61-4861 and JP-A-3-212460 have been extensively used from the viewpoint of printability, curability, mar

15 resistance, etc. These composition systems, however, involve the following problems. Since the diallyl phthalate-based polymer has no photo-reactivity, a photopolymerization initiator should be used in said composition systems in a larger amount than in

20 composition systems composed of a radical-polymerizable monomer and an oligomer in order to attain a practical curing rate. In addition, when a large amount of the aforesaid diallyl phthalate-based polymer is added ~~for~~ controlling to control the polymerization shrinkage and

25 improving the adhesive properties to a substrate, the viscosity is extremely increased, so that the printability ~~involving~~, leveling properties, appearance and the like ~~is~~ are deteriorated.

When the composition system disclosed is used as colored printing ink, its curing rate tends to decrease ~~as compared with~~to an uncolored composition, because of the remarkable light absorption by a dye or  
5 pigment for the coloring. Therefore, a larger amount of a photopolymerization initiator ~~was~~is necessary in order to attain a practical curing rate.

Moreover, when the amount of the photopolymerization initiator is increased in order to  
10 improve the curability, the surface curability is improved, but the in-depth curability ~~in depth~~ was not sufficient owing to remarkable light absorption in the surface layer, with the result that ~~resulting in that~~ the adhesive properties of the resulting coating film  
15 to a substrate ~~is~~are deteriorated.

Thus, it has been difficult to ~~impart~~obtain all ~~of~~ three conflicting characteristics, i.e., a low viscosity, low shrink properties and a rapid curability ~~te~~in a solvent-free radiation curable resin composition  
20 in all applications of the fields ~~where the resin composition is applied~~. ~~For solving~~ To solve this problem, a method of foaming the resin composition during curing in order to prevent cure shrinkage, and a method of adding solid fine particles as disclosed in  
25 JP-A-7-228644, etc. have been proposed. These methods, however, ~~are disadvantageous~~have the disadvantage in that when the obtained resin composition ~~obtained by either of the methods~~ is used as a coating material,

the resulting cured coating film has an unsatisfactory appearance.

The reactive microgels disclosed in Japanese Patent No. 2703125 and JP-B-6-25210 are crosslinked  
5 fine particles with a small particle size and reactivity and, hence, ~~have no undesirable~~ do not undesirably influence ~~on the coating appearance of~~ coating, so ~~that~~ they might be capable of solving the above problems. However, although these microgels are  
10 suitable for use in a resist composition for lithographic plates, they cannot achieve the ~~attainment of a~~ low viscosity intended according to the present invention, for the following reason. The crosslinking density of particles of the microgel ~~are~~ is so low that  
15 a solvent-free coating material cannot be obtained by mixing fine particles of the microgel with another radical-polymerizable monomer because the fine particles are ~~is~~ swelled by the radical polymerizable monomer during ~~the~~ mixing. The low viscosity was not  
20 obtained with ~~these~~ these microgels.

Thus, conventional radiation curable resins cannot have all ~~of the three~~ characteristics: a low viscosity, low shrink properties and ~~a~~ rapid curability. Also ~~in~~ during the production of a heat-  
25 cured coating film or a heat-cured molded article, there was a problem with ~~attaining~~ achieving both a low viscosity and low shrink properties.



## SUMMARY OF THE INVENTION

An object of the present invention is to provide a resin composition having all of the above-mentioned various properties at the same time and a  
5 crosslinked-fine-particle dispersion type curable resin composition using the aforesaid resin composition, by dispersing specific crosslinked fine particles in ~~ana~~ radiation curable resin or a thermosetting resin composition.

10           The present inventors ~~earnestly investigated in order to solve the above problems, and consequently~~ have found that all ~~of~~ the three characteristics, a low viscosity, low shrink properties and a rapid curability can be ~~attained~~ obtained at the same time by dispersing  
15 crosslinked fine particles (A) obtained by polymerizing a compound (a<sub>1</sub>) having one or two radical-polymerizable ethylenic unsaturated groups in the molecule and a compound (a<sub>2</sub>) having three or more (meth)acryloyl groups in the molecule, in a compound (B) having at least one  
20 (meth)acryloyl group in the molecule.

That is, the present invention is a curable resin composition substantially free of water and solvents which is characterized by comprising

                  crosslinked fine particles (A) with an  
25 average primary-particle diameter in a range of 10 to 1,000 nm obtained by polymerizing a compound (a<sub>1</sub>) having one or two radical-polymerizable ethylenic unsaturated groups in the molecule and a compound (a<sub>2</sub>) having three

or more (meth)acryloyl groups in the molecule, and  
a compound (B) having at least one  
(meth)acryloyl group in the molecule.

The use of the crosslinked fine particles of  
5 the present invention enabled the same extent of  
shrinkage reduction with less viscosity increase ~~as~~  
~~compared with the case where~~ to cases in which a the  
conventional polymer or oligomer was incorporated.  
Moreover, the curing rate can be overwhelmingly  
10 increased. Therefore, unlike conventional radiation  
curable resin compositions, a curable resin composition  
can be obtained which satisfies all ~~of~~-three  
characteristics, i.e., ~~a~~-low viscosity, low shrinkage  
properties and ~~a rapidly-rapid~~ curability ~~unlike~~  
15 ~~conventional radiation curable resin compositions~~.  
Accordingly, ~~said~~ the crosslinked fine particles are  
useful in various fields such as ~~the fields of~~ casting  
resins, coating materials, adhesives, inks, stereo  
lithography, photoresists, etc.

## 20 PREFERRED EMBODIMENT OF THE INVENTION

The components of the resin composition and  
crosslinked-fine-particle dispersion type resin  
composition of the present invention are explained  
below in detail.

25 In the present specification, the term  
“(meth)acrylic acid” means “acrylic acid and/or  
methacrylic acid” , and the term “(meth)acryloyl

group" means "acryloyl group and/or methacryloyl group" .

The crosslinked fine particles (A) which constitute the present invention are fine particles  
5 obtained by polymerizing a compound ( $a_1$ ) having one or two radical-polymerizable ethylenic unsaturated groups in the molecule and a compound ( $a_2$ ) having three or more (meth)acryloyl groups in the molecule. In the present specification, the crosslinked fine particles (A) refer  
10 to dried ~~ones~~particles which are free of water and organic solvents.

The structure of the crosslinked fine particles (A) used in the present invention is not particularly limited and may be any of a single-layer  
15 structure, core/shell structure, laminated structure, etc.

The crosslinked fine particles (A) used in the present invention ~~has~~have the following characteristics not attained before: they ~~do not~~cause  
20 only ~~cause~~a slight viscosity increase when added to a dispersion medium component (B), ~~but~~and they decrease the polymerization shrinkage of the resin composition.

The component ( $a_1$ ) used for obtaining the crosslinked fine particles (A) is a compound ( $a_1$ ) having  
25 one or two radical-polymerizable ethylenic unsaturated groups in the molecule, and may be properly chosen in view of the purpose of use, required properties, etc. of the resin composition of the present invention.

Specific examples of the component ( $a_1$ ) include aromatic vinyl monomers such as styrene,  $\alpha$ -methylstyrene,  $\alpha$ -chlorostyrene, vinyltoluene, divinylbenzene, etc.; vinyl ester monomers such as

5 vinyl acetate, vinyl butyrate, N-vinylformamide, N-vinylacetamide, N-vinyl-2-pyrrolidone, N-vinylcaprolactam, divinyl adipate, etc.; vinyl ethers such as ethyl vinyl ether, phenyl vinyl ether, etc.; acrylamides such as acrylamide, N-methylolacrylamide,

10 N-methoxymethyl acrylamide, N-butoxymethyl acrylamide, N-t-butyl acrylamide, acryloylmorpholine, methylenebisacrylamide, etc.; (meth)acrylic acid; and (meth)acrylic acid esters such as methyl

(meth)acrylate, ethyl (meth)acrylate, propyl

15 (meth)acrylate, n-butyl (meth)acrylate, i-butyl (meth)acrylate, t-butyl (meth)acrylate, hexyl (meth)acrylate, 2-ethylhexyl (meth)acrylate, lauryl (meth)acrylate, stearyl (meth)acrylate, tetrahydrofurfuryl (meth)acrylate, 2-hydroxyethyl

20 (meth)acrylate, 2-hydroxypropyl (meth)acrylate, 4-hydroxybutyl (meth)acrylate, glycidyl (meth)acrylate, dimethylaminomethyl (meth)acrylate, diethylaminomethyl (meth)acrylate, benzyl (meth)acrylate, cyclohexyl (meth)acrylate, phenoxyethyl (meth)acrylate,

25 tricyclodecane (meth)acrylate, allyl (meth)acrylate, 2-ethoxyethyl (meth)acrylate, isobornyl (meth)acrylate, phenyl (meth)acrylate, ethylene glycol di(meth)acrylate, polyethylene glycol di(meth)acrylate,

1,3-butylene glycol di(meth)acrylate, 1,4-butanediol di(meth)acrylate, 1,6-hexanediol di(meth)acrylate, neopentyl glycol di(meth)acrylate, neopentyl glycol hydroxypivalate di(meth)acrylic acid ester,

5 polypropylene glycol di(meth)acrylate, bisphenol A polyoxyethylene di(meth)acrylate, hydrogenated bisphenol A polyoxyethylene di(meth)acrylate, hydrogenated bisphenol A di(meth)acrylate, cyclohexanedimethanol di(meth)acrylate, cyclohexanediol

10 di(meth)acrylate, tricyclodecanedimethanol di(meth)acrylate, polytetramethylene glycol di(meth)acrylate, etc. Among these, preferred are (meth)acrylic acid, methyl (meth)acrylate, ethyl (meth)acrylate, propyl (meth)acrylate, n-butyl

15 (meth)acrylate, i-butyl (meth)acrylate, t-butyl (meth)acrylate, ethylene glycol di(meth)acrylate, 1,3-butylene glycol di(meth)acrylate, 1,4-butanediol di(meth)acrylate, 1,6-hexanediol di(meth)acrylate, neopentyl glycol di(meth)acrylate, etc.

20 The above-exemplified compounds may be used either singly or in combination.

Next, the component ( $a_2$ ) used for obtaining the crosslinked fine particles (A) is a compound having three or more (meth)acryloyl groups in the molecule.

25 This compound ( $a_2$ ) having three or more (meth)acryloyl groups has a high reactivity and an excellent crosslinking effect and hence is a crosslinking agent component necessary for crosslinking the above-

mentioned component ( $a_1$ ) at a high density.

Furthermore, ~~the synthesis of~~ synthesizing the crosslinked fine particles ~~by using~~ using the crosslinking agent ( $a_2$ ) with three or more

5 (meth)acryloyl groups enables ~~to leave~~ a large number of radical-polymerizable ethylenic unsaturated groups derived from the crosslinking agent remaining, on the surfaces and/or in ~~their inner parts~~ the interior of the crosslinked fine particles.

10 In the present invention, when only a compound having two (meth)acryloyl groups is used as a crosslinking agent in place of the component ( $a_2$ ), crosslinked fine particles having a low crosslinking density tend to be obtained. Therefore, when these  
15 fine particles are dispersed in the compound (B) having at least one (meth)acryloyl group in the molecule, the component (B) infiltrates into the fine particles, so that the viscosity of the resulting resin composition tends to be extremely increased. In this case, the  
20 number of radical-polymerizable ethylenic unsaturated groups remaining in the crosslinked fine particles tends to be very small, so that it tends to be impossible to increase the curing rate of the curable composition ~~containing~~ that contains the crosslinked  
25 fine particles.

Specific examples of the component ( $a_2$ ) include (meth)acrylic acid esters such as trimethylolpropane tri(meth)acrylic acid ester,

ethoxylated trimethylolpropane tri(meth)acrylic acid ester, propoxylated trimethylolpropane tri(meth)acrylic acid ester, glycerol tri(meth)acrylic acid ester, ethoxylated glycerol tri(meth)acrylic acid ester,

5 tris(acryloxyethyl) isocyanurate, ditrimethylolpropane tetra(meth)acrylic acid ester, pentaerythritol tri(meth)acrylic acid ester, pentaerythritol tetra(meth)acrylic acid ester, dipentaerythritol penta(meth)acrylic acid ester, dipentaerythritol

10 hexa(meth)acrylic acid ester, etc.; urethane poly(meth)acrylates obtained by adding a (meth)acrylate having a hydroxyl group +(e.g. 2-hydroxyethyl (meth)acrylate, 2-hydroxypropyl (meth)acrylate, 4-hydroxybutyl (meth)acrylate and a caprolactone adduct

15 thereof+) to a trimer or higher-order oligomer of a diisocyanate compound +(e.g. hexamethylene diisocyanate, isophorone diisocyanate, tolylene diisocyanate, xylylene diisocyanate, diphenylmethane diisocyanate and hydrogenated diphenylmethane

20 diisocyanate+); and epoxy poly(meth)acrylates obtained by adding (meth)acrylic acid to a polyepoxy compound having three or more epoxy groups in the molecule, such as a trifunctional or higher-order polyfunctional phenolic novolak type epoxy resin, a trifunctional or

25 higher-order polyfunctional cresol novolak type epoxy resin, pentaerythritol polyglycidyl ether, trimethylolpropane triglycidyl ether, triglycidyltris(2-hydroxyethyl) isocyanurate

or the like. Among these compounds, when  
trimethylolpropane tri(meth)acrylic acid ester,  
ditrimethylolpropane tetra(meth)acrylic acid ester,  
pentaerythritol tri(meth)acrylic acid ester,  
5 pentaerythritol tetra(meth)acrylic acid ester,  
dipentaerythritol penta(meth)acrylic acid ester,  
dipentaerythritol hexa(meth)acrylic acid ester or the  
like are used, double bonds derived from the compound  
(a<sub>2</sub>) tend to be well left on polymerizing the compounds  
10 (a<sub>1</sub>) and (a<sub>2</sub>), which is desirable.

The above-exemplified compounds may be used  
either singly or in combination.

In the present invention, the proportions of  
the compounds constituting the crosslinked fine  
15 particles (A), i.e., the compound (a<sub>1</sub>) having one or two  
radical-polymerizable ethylenic unsaturated groups in  
the molecule and the compound (a<sub>2</sub>) having three or more  
(meth)acryloyl groups in the molecule are not  
particularly limited. The proportion of the component  
20 (a<sub>1</sub>) ranges preferably from 55 to 95 wt%, more  
preferably, 65 to 95 wt%, in the total proportion (100  
wt%) of the component (a<sub>1</sub>) and the component (a<sub>2</sub>). The  
proportion of the component (a<sub>2</sub>) ranges preferably from  
5 to 45 wt%, more preferably, 5 to 35 wt%.

25 When the proportion of the component (a<sub>2</sub>)  
relative to the component (a<sub>1</sub>) is less than 5 wt%, the  
crosslinking density of the crosslinked fine particles  
becomes low. Therefore, when the resulting fine



particles are dispersed in the radical-polymerizable unsaturated compound (B), the component (B) infiltrates into the fine particles, so that the viscosity of the resulting resin composition tends to be extremely increased. When the proportion of the component ( $a_2$ ) relative to the component ( $a_1$ ) is more than 45 wt%, gelation tends to take place during the polymerization.

In the present invention, the crosslinked fine particles, component (A), can be obtained by polymerization by a well-known polymerization method. An emulsion polymerization method is especially preferable.

The emulsion polymerization method is not particularly limited. ~~There may be adopted any of, for example, a~~ Examples of emulsion polymerization methods include mixing-in-one-lot polymerization method, monomer dropping method, pre-emulsion method, seed polymerization method, multi-stage (core/shell) polymerization method, etc.

When the above-exemplified emulsion polymerization method is adopted, the polymerization is preferably carried out with the use of an emulsifying agent in order to produce the crosslinked fine particles industrially.

Specific examples of emulsifying agent suitable for obtaining the crosslinked fine particles used in the present invention include nonionic surfactants such as polyethylene glycol nonylphenyl

ether, polyethylene glycol dodecylphenyl ether, etc.;  
anionic surfactants such as sodium lauryl sulfate,  
sodium laurylbenzenesulfonate, sodium  
dodecylbenzenesulfonate, sodium dialkylsulfosuccinates,  
5 etc.,; and reactive surfactants such as polyoxyethylene  
alkylphenyl ether acrylic acid esters, polyoxyethylene  
alkylpropenylphenyl ethers, polyoxyethylene  
alkylpropenylphenyl ether sulfuric acid ester ammonium  
salts, ammonium salt of  $\alpha$ -sulfo- $\omega$ -(1-  
10 ((nonylphenoxy)methyl)-2- (2-propenyloxy)ethoxy) -  
poly(oxy-1,2-ethanediyl), etc.

Among the above-exemplified emulsifying  
agents, the anionic surfactants superior in emulsifying  
capability are preferable. Radical-reactive anionic  
15 surfactants that can be incorporated into the fine  
particles are more preferable for improving the  
durability of a coating film.

The proportion of the emulsifying agent used  
is preferably 0.1 to 8 wt% based on the total weight of  
20 the component (a<sub>1</sub>), the component (a<sub>2</sub>) and pure water at  
the time of emulsion polymerization. Specifically, the  
following proportions are preferable: pure water 100 to  
300 parts by weight, the total amount of the component  
(a<sub>1</sub>), and the component (a<sub>2</sub>) (= polymerizable monomers)  
25 50 to 150 parts by weight, and the emulsifying agent  
0.45 to 13 parts by weight.

The crosslinked fine particles (A) thus  
obtained are blended with the compound (B) after being

dried by water removal.

The component (A) used in the present invention refers to one which is in a dried and pulverized state. ~~A method for drying~~ The drying  
5 method is not particularly limited and includes a method comprising coagulation, washing, drying and then pulverization, a spray drying method, etc.

For example, when the curable resin composition of the present invention is utilized as an  
10 radiation curable resin composition, the spray drying method is ~~preferably adopted~~ preferred because it gives fine particles (A) having a small average particle diameter of aggregated particles, which tend to be easily dispersed when mixed with a resin composition.

15 The average primary-particle diameter of the cross-linked fine particles (A) used in the present invention ranges from 10 to 1,000 nm. The reason is as follows. When the average primary-particle diameter of the component (A) is less than 10 nm, the viscosity of  
20 the resulting resin composition tends to be ~~extremely~~ greatly increased. When the average primary-particle diameter of the component (A) is more than 1,000 nm, the appearance of a cured coating film of the resulting resin composition tends to be unsatisfactory.

25 The especially preferable range of the average primary-particle diameter is 50 to 800 nm. The average primary-particle diameter ranges more preferably from 50 to 250 nm from the viewpoint of the

transparency of a coating film.

In the present invention, the percentage of cubical expansion of the crosslinked fine particles (A) in methyl ethyl ketone at 25°C is not particularly limited. The percentage of cubical expansion is preferably 300% or less because when such fine particles are dispersed in the radical-polymerizable unsaturated compound (B), the viscosity of the resulting resin composition tends to be not extremely increased when the component (B) infiltrates into the fine particles. The percentage of cubical expansion is preferably, in particular, 250% or less.

In order to obtain the crosslinked fine particles (A) having a percentage of cubical expansion in methyl ethyl ketone at 25°C of 300% or less, the proportions of the compounds constituting the crosslinked fine particles (A), i.e., the ethylenic unsaturated compound (a<sub>1</sub>) and the compound (a<sub>2</sub>) having three or more (meth)acryloyl groups in the molecule are as follows: in the total proportion (100 wt%) of the component (a<sub>1</sub>) and the component (a<sub>2</sub>), the proportion of the component (a<sub>1</sub>) ranges preferably from 95 to 65 wt%, and the proportion of the component (a<sub>2</sub>) ranges from 5 to 35 wt%.

In the present invention, the percentage of cubical expansion (%) in methyl ethyl ketone of the crosslinked fine particles (A) is calculated by the following method.

The primary-particle diameter of crosslinked fine particles obtained by the above-mentioned emulsion polymerization method is measured at 25°C by a dynamic light scattering method, and the average particle diameter of the crosslinked fine particles is taken as  $R_1$ . The dried and pulverized ~~to obtain~~ crosslinked fine particles (A) are re-dispersed in methyl ethyl ketone at 25°C and their average particle diameter is measured by using the same system as above. This average particle diameter is taken as  $R_2$ .

~~A~~The method for dispersing the crosslinked fine particles (A) in methyl ethyl ketone is not particularly limited. The crosslinked fine particles (A) can be dispersed by the use of any dispersing machine such as a homodisperser, dissolver, three roll mill, ball mill or the like after being mixed with methyl ethyl ketone. The percentage of cubical expansion (%) in an organic solvent of the crosslinked fine particles is represented by  $V$  (%) in the following equation:

$$V = (R_2)^3 / (R_1)^3 \times 100$$

The amount of double bonds remaining in the dried and pulverized crosslinked-fine-particles (A) used in the present invention is preferably 0.01 mmol/g or more. When the amount of the remaining double bonds is less than 0.01 mmol/g, the curability of the resulting curable composition containing the

crosslinked fine particles (A) dispersed therein tends to be not improved, which is not desirable. Although ~~at~~the method for determining the amount of the remaining double bonds is not particularly limited, a value  
5 determined by the following determination method is defined as the amount of the remaining double bonds in the present invention.

One gram of the crosslinked fine particles (A) obtained are accurately measured (the accurately  
10 measured amount is taken as x g), and then the crosslinked fine particles accurately measured, 20 g of water and 4 g of tetrahydrofuran (THF) are placed in a 200-ml flask and stirred for 30 minutes. To the resulting mixture are added 10 ml of a 0.1N KBrO<sub>3</sub>  
15 aqueous solution and 5 ml of 6N HCl, immediately after which the flask was closed with a plug, followed by stirring in the dark for 5 minutes. Bromine is thus produced and added to double bonds remaining in the crosslinked fine particles. After the flask was  
20 allowed to stand in a dark room for 30 minutes, 5 ml of a 15 wt% KI aqueous solution is added into the flask while cooling the flask with ice water, and the resulting mixture is stirred for 5 minutes. By this stirring, non-added bromine is replaced with iodine.  
25 The iodine produced is titrated with a 0.1N Na<sub>2</sub>S<sub>2</sub>O<sub>3</sub> aqueous solution. The titration end point is a point at which the color of the dark-brown liquid changes to colorless or yellow. The amount of the remaining

double bonds is determined from the titer according to the following equation:

$$\begin{aligned} \text{Amount of remaining double bonds (mmol/g)} = \\ 1/2 \times \{((\text{titer for blank}) - (\text{titer for sample}))\} \times \\ 5 \quad 0.1 \times f \times (1/x) \end{aligned}$$

wherein the titer for blank is the titer (ml) of the 0.1N Na<sub>2</sub>S<sub>2</sub>O<sub>3</sub> aqueous solution measured in the case of not using the sample (the fine particles) in the above determination method; the titer for sample is the titer (ml) of the 0.1N Na<sub>2</sub>S<sub>2</sub>O<sub>3</sub> aqueous solution measured in the case of using the sample (the fine particles) in the above determination method; f is a factor for 0.1N Na<sub>2</sub>S<sub>2</sub>O<sub>3</sub>; and x is the amount (g) of the sample (the fine particles) accurately measured.

15           The glass transition temperature (T<sub>g</sub>) of the dried and pulverized crosslinked-fine-particles (A) used in the present invention is preferably 100°C or higher. When the glass transition temperature (T<sub>g</sub>) is lower than 100°C, the curability of the resulting  
20 curable composition containing the crosslinked fine particles (A) dispersed therein tends to be not improved, which is not desirable. A method for measuring the T<sub>g</sub> is not particularly limited. In the present invention, the dried and pulverized  
25 crosslinked-fine-particles (A) are placed directly on a glass stage, and the T<sub>g</sub> is defined as a thermal and

mechanical value determined from a change of the thermal expansion coefficient by using the TMA method.

The resin composition of the present invention is obtained by blending by dispersion the crosslinked fine particles (A) with the component (B). A method for dispersing the component (A) in the component (B) to blend them is not particularly limited. The component (A) can be dispersed in component (B) by the use of any dispersing machine such as a homodisper, dissolver, triple-roll mill, ball mill or the like after being mixed with the component (B).

In the present invention, the compound (B) having at least one (meth)acryloyl group in the molecule is used as a dispersion medium for the component (A).

As specific examples of the component (B), the (meth)acrylic acid esters mentioned above as specific examples of the component (a<sub>1</sub>), and the component (a<sub>2</sub>) can be used. In addition to ~~them~~these, there can be mentioned, for example, polyester poly(meth)acrylates obtained by the reaction of a polybasic acid +(e.g. phthalic acid and adipic acid)+, a polyhydric alcohol +(e.g. ethylene glycol, hexanediol, poly(ethylene glycol)s, poly(tetramethylene glycol)s)+ and (meth)acrylic acid or its derivative; epoxy poly(meth)acrylates obtained by reacting a glycidyl ether compound +(e.g. bisphenol A diglycidyl ether and ethylene glycol diglycidyl ether)+ with a



(meth)acrylic acid or its derivative; and urethane poly(meth)acrylates obtained by reacting an isocyanate compound {e.g. hexamethylene diisocyanate, isophorone diisocyanate, tolylene diisocyanate, xylylene diisocyanate, diphenylmethane diisocyanate, and hydrogenated diphenylmethane diisocyanate} with a (meth)acrylate having a hydroxyl group {e.g. 2-hydroxyethyl (meth)acrylate, 2-hydroxypropyl (meth)acrylate and 4-hydroxybutyl (meth)acrylate}.

10                    These may be used either singly or in combination.

                  The proportions of the crosslinked fine particles (A) and the compound (B) are as follows: in the total proportion (100 wt%) of the component (A) and the component (B), the proportion of the component (A) ranges from 5 to 50 wt%, and the proportion of the component (B) ranges from 50 to 95 wt%.

                  When the proportion of the component (A) is more than 50 wt%, the resulting resin composition has a high viscosity, so that its coatability tends to be poor. When the proportion of the component (A) is less than 5 wt%, the curability and low shrink properties intended according to the present invention tend to be ~~not sufficiently exhibited~~ insufficient.

25                    It is preferable to incorporate radical polymerization initiators (C) such as photopolymerization initiators (C<sub>1</sub>), thermal polymerization initiators (C<sub>2</sub>) and the like properly

into the curable resin composition of the present invention.

Specific examples of the photopolymerization initiators ( $c_1$ ) include benzophenone, 4,4-bis(diethylamino)benzophenone, t-butylanthraquinone, 2-ethylanthraquinone, and thioxanthenes (e.g. 2,4-diethylthioxanthone, isopropylthioxanthone and 2,4-dichlorothioxanthone); acetophenones such as diethoxyacetophenone, 2-hydroxy-2-methyl-1-phenylpropan-1-one, benzyl dimethyl ketal, 1-hydroxycyclohexyl phenyl ketone, 2-methyl-2-morpholino(4-thiomethylphenyl)propan-1-one, 2-benzyl-2-dimethylamino-1-(4-morpholinophenyl)-butanone, etc.; benzoin ethers such as benzoin methyl ether, benzoin ethyl ether, benzoin isopropyl ether, benzoin isobutyl ether, etc.; acylphosphine oxides such as 2,4,6-trimethylbenzoyl-diphenylphosphine oxide, bis(2,6-dimethoxybenzoyl)-2,4,4-trimethylpentylphosphine oxide, bis(2,4,6-trimethylbenzoyl)-phenylphosphine oxide, etc.; methylbenzoyl formate; 1,7-bisacrydinylheptane; 9-phenylacridine; etc.

These photopolymerization initiators ( $c_1$ ) may be used singly or in combination and are incorporated into the present resin composition comprising the component (A) and the component (B), in a proportion of preferably 0.01 to 20 parts by weight, in particular, 0.1 to 10 parts by weight, per 100 parts by weight of the resin composition.

In addition, if necessary, well-known photosensitizers such as methyl 4-dimethylaminobenzoate, ethyl 4-dimethylaminobenzoate, amyl 4-dimethylamino- benzoate, 4-  
5 dimethylaminoacetophenone, etc. may be incorporated into the curable resin composition of the present invention.

Specific examples of the thermal polymerization initiators ( $C_2$ ) include organic peroxides  
10 such as methyl ethyl ketone peroxide, benzoyl peroxide, dicumyl peroxide, t-butyl hydroperoxide, cumene hydroperoxide, t-butyl peroxyoctoate, t-butyl peroxybenzoate, lauroyl peroxide, etc.; azo compounds such as azobisisobutyronitrile, etc.; and redox  
15 polymerization initiators obtained by combining amines (e.g. N,N-dimethylaniline and N,N-dimethyl-p-toluidine) with any of the above-mentioned peroxides. The 10-hours half-life temperature of these thermal polymerization initiators ( $C_2$ ) is preferably 100°C or  
20 lower. If a thermal polymerization initiator having a 10-hours half-life temperature of higher than 100°C is used, the curing rate tends not to be increased.

If necessary, metal soaps such as cobalt naphthenate, manganese naphthenate, nickel octylate,  
25 etc. may also be used.

These thermal polymerization initiators ( $C_2$ ) may be used either singly or in combination and are incorporated into the resin composition comprising the

component (A) and the component (B), in a proportion of preferably 0.001 to 10 parts by weight, in particular, 0.01 to 5 parts by weight, per 100 parts by weight of the resin composition.

5                In addition, well-known additives such as mold release agents, lubricants, plasticizers, antioxidants, ultraviolet absorbers, flame retardants, flame-retarding assistants, polymerization inhibitors, fillers, organic solvents usable in the present  
10 invention, pigments, dyes, silane coupling agents, etc. may be properly used depending on their purpose, in the resin composition and crosslinked-fine-particle dispersion type curable resin composition of the present invention.

15                The curable resin composition of the present invention is useful as a composition substantially free of water and solvents. The viscosity of said composition is preferably 10 Pa·s or less at 25°C, more preferably 5 Pa·s or less at 25°C, from the viewpoint  
20 of work-efficiency. A curable resin composition having a viscosity of more than 10 Pa·s at 25°C requires heating in some cases at the time of coating or printing in order to reduce the viscosity and, thus, tends to result in the deterioration of the  
25 productivity. Moreover, even if the application or printing with such composition is possible the appearance of the resulting coating or print tends to be unsatisfactory, which is not desirable.

The curable resin composition of the present invention can be used in any of the fields of molded articles, adhesives, coating materials, inks, resins for stereo lithography, photoresists, etc. ~~A~~The method  
5 for curing said resin composition is not particularly limited, and the resin composition can be cured by various curing methods well known and conventionally used in the fields mentioned above.

In particular, ~~said the~~ resin composition  
10 causes only a slight viscosity increase when added to a dispersion medium, it is excellent in curability and can have low shrink properties. Therefore, ~~said the~~ resin composition ~~can~~ can exhibit its performance characteristics to the utmost when used as ~~an~~  
15 radiation curable resin which can be used, for example, for film coatings and wood coatings and in printing inks.

The present invention is concretely illustrated below with examples and comparative  
20 examples.

#### Example 1

{(Preparation of a starting pre-emulsion)}

A pre-emulsion was obtained by mixing 55 parts by weight of methyl methacrylate, 30 parts by  
25 weight of n-butyl methacrylate, 15 parts by weight of PETA (a mixture consisting of 60% of pentaerythritol triacrylate and 40% of pentaerythritol tetraacrylate),

0.3 part by weight of a peroxide initiator (Perbutyl H, a trade name, mfd. by Nippon Oils and Fats Co., Ltd.), 3 parts by weight of sodium dodecylbenzene- sulfonate and 55 parts by weight of pure water, and stirring the  
5 resulting mixture continuously.

†(Preparation of crosslinked fine particles)†

In a 2-liter four-necked flask were placed 145 parts by weight of pure water, 0.3 part by weight of Rongalite, 0.01 part by weight of ethylenediamine-  
10 N,N,N',N'-tetraacetic acid disodium salt and 0.0025 part by weight of ferrous sulfate heptahydrate, and they were stirred at 150 rpm with an anchor-shaped stirring rod.

After the air in the system was replaced with  
15 nitrogen gas introduced into the system, the temperature was begun to be raised. When the internal temperature reached 60°C, dropwise addition of the pre-emulsion was started and 40 parts by weight of the pre-emulsion was added dropwise in 30 minutes, followed by  
20 continuous stirring at an internal temperature of 60°C for 30 minutes. Then, the whole of 120 parts by weight of the residual starting pre-emulsion was added dropwise in 2 hours. The resulting mixture was continuously stirred for 2 hours while maintaining the  
25 internal temperature at 60°C, and was then cooled to obtain a milk-white emulsion. A portion of the obtained emulsion was sampled and its average primary-

particle diameter  $R_1$  at 25°C was measured with a dynamic light-scattering photometer DLS-600 manufactured by Otsuka Electronics Co., Ltd. The result obtained is shown in Table 1.

- 5                   The obtained emulsion was subjected to spray drying with a spray dryer Model L-8 manufactured by Ohkawara Kakohki Co., Ltd., to obtain crosslinked fine particles (P1).

                  The spray drying conditions were as follows:  
10 chamber inlet temperature of 120°C, chamber outlet temperature of 60°C, and the number of revolution of an atomizer of 25,000 rpm. The thus obtained powder contained no blocking substance and had a high fluidity.

- 15    {Preparation of a dispersion of the fine particles in methyl ethyl ketone}

                  A milk-white resin composition was obtained by mixing 20 parts by weight of the crosslinked fine particles (P1) obtained and 80 parts by weight of  
20 methyl ethyl ketone, and stirring the resulting mixture in a homodisper for 5 minutes at a number of revolution of 2,000 rpm. A portion of the obtained milk-white resin composition was sampled and its average primary-particle diameter  $R_2$  at 25°C was measured with a dynamic  
25 light-scattering photometer DLS-600 manufactured by Otsuka Electronics Co., Ltd. The result obtained is shown in Table 1.

†(Evaluation of the percentage of cubical expansion of the crosslinked fine particles in the organic solvent)†

The percentage of cubical expansion of the crosslinked fine particles in the organic solvent was  
5 calculated from the average primary-particle diameter  $R_1$  of the emulsion in water after the emulsion polymerization and the average primary-particle diameter  $R_2$  of the fine particles in methyl ethyl ketone, and is shown in Table 1.

10 †(Evaluation of the amount of double bonds remaining in the crosslinked fine particles)†

One gram of the crosslinked fine particles (P1) obtained were accurately measured (the accurately measured amount is taken as x g), and then the  
15 crosslinked fine particles accurately measured, 20 g of water and 4 g of tetrahydrofuran (THF) were placed in a 200-ml flask and stirred for 30 minutes. To the resulting mixture were added 10 ml of a 0.1N  $\text{KBrO}_3$  aqueous solution and 5 ml of 6N  $\text{HCl}$ , immediately after  
20 which the flask was closed with a plug, followed by stirring in the dark for 5 minutes (bromine is thus produced and added to double bonds remaining in the crosslinked fine particles). After the flask was allowed to stand in a dark room for 30 minutes, 5 ml of  
25 a 15 wt%  $\text{KI}$  aqueous solution was placed in the flask while cooling the flask with ice water, and the



resulting mixture was stirred for 5 minutes (bromine not added to double bonds is replaced with iodine in this way). The iodine produced was titrated with a 0.1N  $\text{Na}_2\text{S}_2\text{O}_3$  aqueous solution. The titration end point was a point at which the color of the dark-brown liquid had changed to colorless or yellow. Table 1 shows the result of determining the amount of the remaining double bonds from the titer according to the following equation:

$$\begin{aligned} 10 \quad \text{Amount of remaining double bonds (mmol/g)} = & \\ & \frac{1}{2} \times \{(\text{titer for blank}) - (\text{titer for sample})\} \\ & \times \\ & 0.1 \times f \times (1/x) \end{aligned}$$

wherein the titer for blank is the titer (ml) of the 0.1N  $\text{Na}_2\text{S}_2\text{O}_3$  aqueous solution measured in the case of not using the sample (the fine particles) in the above determination method; the titer for sample is the titer (ml) of the 0.1N  $\text{Na}_2\text{S}_2\text{O}_3$  aqueous solution measured in the case of using the sample (the fine particles) in the above determination method; f is a factor for 0.1N  $\text{Na}_2\text{S}_2\text{O}_3$ ; and x is the amount (g) of the sample (the fine particles) accurately measured.

{Evaluation of the glass transition temperature of the crosslinked fine particles}

25                   The crosslinked fine particles (P1) obtained

were placed directly on a glass stage and subjected to TMA measurement in a temperature range of 20°C to 250°C at a heating rate of 10°C/min by using a quartz probe. A temperature at which the expansion coefficient had  
5 changed was determined from a thermal expansion curve measured by the TMA method and is shown as T<sub>g</sub> in Table 1.

{(Preparation of an radiation curable resin composition)}

10                   Thirty parts by weight of the crosslinked fine particles (P1) obtained, 20 parts by weight of dipentaerythritol hexaacrylate, 50 parts by weight of tripropylene glycol diacrylate and 5 parts by weight of 1-hydroxycyclohexyl phenyl ketone as a  
15 photopolymerization initiator were mixed and then stirred for 5 minutes in a homodisper at a number of revolution of 4,000 rpm to obtain a milk-white radiation curable resin composition. The evaluation results of film performance for the resin composition  
20 are described below.

{(Evaluation of the radiation curable resin composition)}

For the radiation curable resin composition obtained, the E-type viscosity at 25°C and the  
25 polymerization shrinkage determined from the difference between the specific gravities of the liquid

composition and a cured product thereof are shown in Table 2.

Curability:

The resin composition was applied on the  
5 primer-coated surface of a PET film A-4100 manufactured  
by Toyobo Co., Ltd., with a bar coater #3, and was  
irradiated with ultraviolet rays from a high-pressure  
mercury lamp of 120 w/cm at a lamp height of 10 cm and  
a conveyor speed of 50 m/min. Table 2 shows a number  
10 of irradiation operations at which the cured film  
surface became tack-free in a dry to the touch test.

A criterion for evaluation by the dry to the  
touch test is as follows:

- Good: The cured film surface became tack-free  
15 after two or less runs of the irradiation.
- Fair: The cured film surface became tack-free  
after not more than 5 and not less than 3 runs  
of the irradiation.
- Poor: The cured film surface became tack-free  
20 after 6 or more runs of the irradiation.

Coatability:

The appearance of the cured film was visually  
evaluated.

- Good: a flat surface having a good appearance.
- 25 Fair: the presence of a few stripes formed by the  
bar coater.
- Poor: unusable because of remarkable unevenness of

the surface.

Adhesive properties:

A cellophane adhesive tape (mfd. by Nichiban Co., Ltd.) was stuck on the cured film obtained in the curability evaluation, and was quickly peeled off, after which the adhered state of the cured film was visually evaluated (a no-cut test). In this case, when the cured film would not be peeled off, notches were made crosswise on the cured film with a cutter knife and the adhered state of the cured film was visually evaluated in the same manner as above (a cross-cut test). A criterion for the evaluation was as follows:

Good: The film was peeled off in neither the no-cut test nor the cross-cut test.

15 Fair: The film was not peeled off in the no-cut test but was peeled off in the cross-cut test.

Poor: The film was peeled off in the no-cut test.

Odor:

The cured film obtained in the curability evaluation was allowed to stand at 20°C and 50% RH for 24 hours, and then subjected to an organoleptic test for odor by maintaining the position of nose at a height of 2 cm above the cured film. The odor was evaluated according to the following criterion:

25 Good: substantially no odor.

Fair: a slight odor.

Poor: a strong odor.

Warpage of the PET film:

The PET film after the coating and the curing obtained in the curability evaluation was allowed to stand at 20°C and 50% RH for 24 hours, and then cut to a size of A4. Then, the sample piece thus obtained was allowed to stand on a plane with the cured film side upward, after which the degree of lifting from the plane was measured for the four corners of the sample piece and the average of the measured values was calculated. The warpage was evaluated according to the following criterion:

Good: The average degree of lifting was less than 3 mm.

15 Fair: The average degree of lifting was 3 mm to 5 mm.

Poor: The average degree of lifting was more than 5 mm.

Examples 2 to 4 and Comparative Example 1

20 Crosslinked fine particles (P2 to P6) having the compositions shown in Table 1 were synthesized by the same process as in Example 1. The crosslinked fine particles of each kind were dispersed in the component (B) to blend them according to the recipe shown in Table 2 as in Example 1, whereby radiation curable resin compositions were obtained. These compositions

were evaluated in the same manner as in Example 1.

The evaluation results are shown in Table 2.

#### Example 5

Blending was conducted in the same manner as  
5 in Example 1 except for using benzoyl peroxide as a  
thermal polymerization initiator in place of the  
photopolymerization initiator among the components used  
in the Example 1. The resulting resin composition was  
applied on a glass substrate with a bar coater #3 and  
10 cured in an oven at 120°C for 10 minutes, and the E-type  
viscosity and the polymerization shrinkage were  
determined in the same manner as in Example 1. E-type  
viscosity was 400 mPa·s and the polymerization  
shrinkage 9.1%. The cured film thus obtained showed  
15 the transparency and good appearance.

#### Comparative Examples 2 to 7

The compositions shown in Table 2 were  
obtained by blending and subjected to evaluation of  
viscosity, polymerization shrinkage, curability, coat-  
20 ing efficiency, adhesive properties and film warpage in  
the same manner as in the case of the radiation curable  
resin composition obtained in Example 1.

Table 1

		P1	P2	P3	P4	P5
Compound (a <sub>1</sub> )	MMA	55	40	60	50	55
	nBMA	30	30			30
	THFMA			30		

	ACMO				30	
	BD					15
Compound (a <sub>2</sub> )	TMPTA		30			
	PETA	15		10	20	
R1 (nm)		180	150	130	90	150
R2 (nm)		230	160	170	110	280
Percentage of cubical expansion (%)		208	121	224	183	650
Amount of double bonds (mmol/g)		0.024	0.018	0.016	0.032	0.006
Tg (°C)		130	150	125	160	95

The abbreviations in Table 1 are as follows:

MMA: methyl methacrylate, nBMA: n-butyl methacrylate,

THFMA: tetrahydrofurfuryl methacrylate, ACMO:

acryloylmorpholine, BD: 1,3-butylene glycol

5 dimethacrylate, TMPTA: trimethylolpropane triacrylate,

PETA: a mixture consisting of 60% of pentaerythritol

triacrylate and 40% of pentaerythritol tetraacrylate.

Table 2

Example										Comparative Example						
1	2	3	4	1	2	3	4	5	6	7						
P1																
P2	20															
P3		15														
P4			35													
P5				20												
P6 <sup>*1)</sup>					20	20										
P7 <sup>*2)</sup>							20	20								
P8 <sup>*3)</sup>									20							
Com-pound (B)	20	30		30	30	30	30	30	30	38						
PETA			20													
TPGDA	50	50	45	50	50	50	50	50	50	62						
Photo-polymerization initiator (C)HCPK	5	5	5	5	5	9	5	9	5	5						
E-type viscosity (mPa·S)	400	300	400	- <sup>*4)</sup>	15000	15000	15000	15000	300	50						
Polymerization shrinkage (%)	9.1	10.4	11.1	- <sup>*4)</sup>	10.4	10.4	10.4	10.4	10.4	13.0						
Coating efficiency	Good	Good	Good	- <sup>*4)</sup>	Poor	Poor	Fair	Fair	Good	Good						
Curability	Good	Good	Good	- <sup>*4)</sup>	Fair	Good	Fair	Good	Poor	Poor						
Adhesive properties	Good	Good	Good	- <sup>*4)</sup>	Good	Good	Good	Good	Poor	Poor						
Odor	Good	Good	Good	- <sup>*4)</sup>	Poor	Poor	Poor	Poor	Poor	Poor						
Paper warpage	Good	Good	Good	- <sup>*4)</sup>	Good	Good	Good	Good	Fair	Poor						



- \*1) P6: a linear polymer (weight average molecular weight 20,000) of MMA/nBMA = 62 wt%/38 wt%.
- \*2) P7: a polystyrene (weight average molecular weight 20,000).
- 5 \*3) P8: crosslinked poly(methyl methacrylate) particles MB20X-5 (average particle diameter 5  $\mu$ m) manufactured by Sekisui Plastics Co., Ltd.
- \*4) Evaluation was impossible because the compound (B) infiltrated into fine particles (P6) in the
- 10 dispersing operation of the fine particles (P6) in the compound (B), so that the whole resin gelled.

The abbreviations in Table 2 are as follows:

- DPHA: dipentaerythritol hexaacrylate,
- PETA: a mixture consisting of 60% of pentaerythritol
- 15 triacrylate and 40% of pentaerythritol tetraacrylate,
- TPGDA: tripropylene glycol diacrylate,
- HCPK: 1-hydroxycyclohexyl phenyl ketone.

{Preparation of an radiation curable resin composition

20 - 2}

#### Example 6

Thirty parts by weight of the crosslinked fine particles (P1) obtained, 50 parts by weight of tripropylene glycol diacrylate, 20 parts by weight of

25 urethane acrylate UK-6091 manufactured by Mitsubishi Rayon Co., Ltd. and 3 parts by weight of 1-hydroxycyclohexyl phenyl ketone as a

photopolymerization initiator were mixed and then stirred for 5 minutes in a homodisper at a number of revolution of 4,000 rpm to obtain a milk-white radiation curable resin composition. The evaluation results of the wood coating performance for the resin composition are described below.

{(Evaluation of the radiation curable resin composition  
- 2)}

Table 3 shows the E-type viscosity at 25°C of the radiation curable resin composition obtained in Example 6.

The radiation curable composition obtained was applied on a plywood with a bar coater #60 and irradiated with ultraviolet rays from a high-pressure mercury lamp of 80 W/cm at a lamp height of 15 cm and a conveyor speed of 10 m/min until the cured film surface became tack-free in a dry to the touch test. The cured film thus obtained was subjected to various performance tests. The results obtained are shown in Table 3.

{(Performance test methods)}

Curability:

A number of ultraviolet irradiation operations required for the cured film surface to become tack-free was measured by touch with a finger, and the curability was evaluated according to the following criterion:

Good: two or less times.

Fair: not more than 5 and not less than 3 times.

Poor: six or more times.

Coating efficiency:

- 5                    The appearance of the cured film was visually evaluated.

Good: a flat surface having a good appearance.

Fair: the presence of a few stripes formed by the bar coater.

- 10                  Poor: unusable because of remarkable unevenness of the surface.

Polymerization shrinkage:

- The polymerization shrinkage was determined from the specific gravities of the liquid composition and the cured film, and was evaluated according to the following criterion:
- 15

Good: less than 8%.

Fair: not more than 10% and not less than 8%.

Poor: more than 10%.

- 20    Crack resistance:

- A cycle test consisting of standing at 80°C for 2 hours and standing at -20°C for 2 hours per cycle was repeated, and the crack resistance was evaluated in terms of a number of cycles that cause a crack in the coating film.
- 25

Good: 50 or more cycles.

Fair: 10 to 49 cycles.

Poor: less than 10 cycles.

#### Examples 7 to 9 and Comparative Example 8

- 5                    Crosslinked fine particles (P2 to P5) having the compositions shown in Table 1 were synthesized by the same process as in Example 1. The crosslinked fine particles of each kind were dispersed in the component (B) to blend them according to the recipe shown in
- 10 Table 3, as in Example 1, whereby radiation curable compositions were obtained. Cured films of these compositions were evaluated in the same manner as in Example 1.

The evaluation results are shown in Table 3.

#### 15 Comparative Examples 9 to 12

- The compositions shown in Table 3 were obtained by blending and subjected to evaluation of viscosity, curability, coating efficiency, polymerization shrinkage and crack resistance in the
- 20 same manner as the evaluation of the radiation curable resin composition obtained in Example 1.

The evaluation results are shown in Table 3.

Table 3

		Example						Comparative Example				
		6	7	8	9	8	9	10	11	12		
Fine particles (A)	P1	30										
	P2		40									
	P3			20								
	P4				10							
	P5					30						
	P6						30					
	P8							30				
	UK-6091	20	17	23	26	20	20	20	29			
Com-pound (B)	UK-1102									50		
	TPGDA	50	43	57	64	50	50	50	71	50		
Photo-polymerization initiator HCPK		3	3	3	3	3	3	3	3	3		
E-type viscosity (mPa·S)		500	600	400	300	- <sup>*5)</sup>	20000	500	300	400		
Curability		Good	Good	Good	Good	- <sup>*5)</sup>	Fair	Poor	Fair	Poor		
Coating efficiency		Good	Good	Good	Good	- <sup>*5)</sup>	Poor	Fair	Good	Good		
Polymerization shrinkage		Good	Good	Good	Good	- <sup>*5)</sup>	Good	Good	Fair	Fair		
Crack resistance		Good	Good	Good	Good	- <sup>*5)</sup>	Good	Fair	Poor	Poor		

Evaluation results

\*5): Evaluation was impossible because the compound (B) infiltrated into fine particles (P5) in the dispersing operation of the fine particles (P5) in the compound (B), so that the whole resin was  
5 gelatinized.

The abbreviations in Table 3 are as follows:  
UK-6091: urethane acrylate manufactured by Mitsubishi Rayon Co., Ltd.,  
UK-1102: an unsaturated polyester manufactured by  
10 Mitsubishi Rayon Co., Ltd.,  
TPGDA: tripropylene glycol diacrylate,  
HCPK: 1-hydroxycyclohexyl phenyl ketone.

†(Preparation of a radiation curable composition - 3†)  
Example 10

15 Thirty parts by weight of the crosslinked fine particles (P1) obtained, 50 parts by weight of ditrimethylolpropane tetraacrylate, 20 parts by weight of neopentyl glycol hydroxypivalate diacrylate, 20 parts by weight of Rionol Red F2B (mfd. by TOYO INK  
20 MFG. CO., LTD) as a pigment and 3 parts by weight of Irgacure 907 (mfd. by Ciba Speciality Chemicals Ltd.) as a photopolymerization initiator were mixed and then subjected to dispersion with a triple roll mill to obtain a radiation curable composition. The results of  
25 evaluation of this composition as printing ink are described below.

{(Evaluation of the radiation curable composition - 3)}

Table 4 shows the result of measuring the E-type viscosity at 25°C of the radiation curable composition obtained in Example 10.

5           Using the radiation curable composition obtained, printing was conducted on coated paper "NK Kata-Art" (mfd. by Nippon Kakoh Seishi Co., Ltd.) with a screen printer so that the thickness of the composition would be 15  $\mu$ m. Then, the printed-paper  
10 placed on a conveyor was passed under a metal halide lamp having an intensity of 120 W/cm, at a lamp height of 10 cm. In dry to the touch evaluation, a maximum line speed at which the cured film surface became tack-free was evaluated according to the following  
15 criterion.

Curability:

Table 4 shows a maximum line speed at which the radiation curable composition became tack-free owing to the irradiation of one passing when the line  
20 speed was increased by increments of 10 m/min.

When a composition was curable at a line speed of 50 m/min or more, the composition was rated eligible. The cured film thus obtained was subjected to performance tests with regard to adhesive properties  
25 and appearance of print. The results obtained are shown in Table 4.

Adhesive properties:

A cellophane adhesive tape (mfd. by Nichiban Co., Ltd.) was stuck on the printing and coating film which had been cured, after which the tape was quickly  
5 peeled off, and the adhered state of the cured film was visually evaluated (a no-cut test). In this case, when the coating film was not peeled off, notches were made crosswise on the cured film with a cutter knife and the adhered state of the cured film was visually evaluated  
10 in the same manner as above (a cross-cut test). The evaluation was carried out according to the following criterion and the result obtained is shown in Table 4:

Good: The film was peeled off in neither the no-cut test nor the cross-cut test.

15 Fair: The film was not peeled off in the no-cut test but was peeled off in the cross-cut test.

Poor: The film was peeled off in the no-cut test.

Appearance of print:

The appearance of the printing was visually  
20 evaluated according to the following criterion. The result obtained is shown in Table 2.

Excellent: The appearance of print was so good that it was smooth and had a high gloss.

Good: The appearance of print was smooth but the  
25 print surface was matte.

Fair: Curing in depth was not sufficient, resulting



in formation of a few wrinkles on the print surface.

Poor: Print was not cured in depth, resulting in formation of a large number of wrinkles on the print surface.

Warpage of the printed paper:

The printed paper after the curing was allowed to stand at 20°C and 50% RH for 24 hours, and then cut to a size of A4. Then, the sample piece thus obtained was allowed to stand on a plane with the cured film side upward, after which the degree of lifting from the plane was measured for the four corners of the sample piece and the average of the measured values was calculated. The warpage was evaluated according to the following criterion:

Good: The average degree of lifting was less than 3 mm.

Fair: The average degree of lifting was 3 mm to 5 mm.

Poor: The average degree of lifting was more than 5 mm.

Examples 11 to 13 and Comparative Example 13

Crosslinked fine particles (P2 to P5) having the compositions shown in Table 1 were synthesized by the same process as in Example 1. The crosslinked fine particles of each kind were dispersed in the component

(B) to blend them according to the recipe shown in Table 4, as in Example 1, whereby radiation curable compositions were obtained. These compositions were evaluated in the same manner as in Example 1.

5                   The evaluation results are shown in Table 4.

Comparative Examples 14 to 18

                  The compositions shown in Table 4 were obtained by blending and subjected to evaluation of curability, adhesive properties, appearance of coating,  
10 and paper warpage in the same manner as the evaluation of the radiation curable resin composition obtained in Example 1.

                  The evaluation results are shown in Table 4.

Table 4

	Example					Comparative Example							
	10	11	12	13	13	13	14	15	16	17	18	17	18
Fine particles (A)													
P1	30												
P2		40											
P3			20										
P4				10									
P5						30							
P9 <sup>*6)</sup>							30	30					
P8									30				
Compound (B)													
DTMPTA	50	43	57	64	50	50	50	50	50	71	71	71	71
HPNDA	20	17	23	26	20	20	20	20	20	29	29	29	29
Photo-polymerization initiator	3	3	3	3	3	3	3	8	3	3	3	8	8
Pigment	20	20	20	20	20	20	20	20	20	20	20	20	20
E-type viscosity (mPa·s)	3000	3500	2000	1000	*7)	*7)	6000	6000	3000	800	800	800	800
Line speed (m/min)	60	60	50	50	*7)	*7)	30	50	30	30	50	50	50
Adhesive properties	Good	Good	Good	Good	*7)	*7)	Good	Fair	Poor	Poor	Poor	Poor	Poor
Appearance of print	Excellent	Excellent	Excellent	Excellent	*7)	*7)	Excellent	Fair	Good	Excellent	Poor	Poor	Poor
Paper warpage	Good	Good	Good	Good	*7)	*7)	Good	Fair	Fair	Poor	Poor	Poor	Poor

\*6) P9: DAP-K (a dially phthalate prepolymer)

manufactured by Daisoh Co., Ltd.

\*7) Further evaluation was impossible because the  
compound (B) infiltrated into fine particles (P5)  
5 in the dispersing operation of the fine particles  
(P5) in the compound (B), so that the whole resin  
was gelatinized.